

Date: Thursday, 29/05/2008 11:09:07 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOOR DOUBLER
<b>Job Number</b> : 39575	
<b>Estimate Number</b> : 12681	
<b>P.O. Number</b> :	<b>Part Number</b> : D3594043
<b>This Issue</b> : 29/05/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3594 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL / MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 38164	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 06/06/2008 <b>Qty:</b> 10 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 08.5.29</u>	
<b>Comment</b> : Est Rev :A New Issue 07-01-22 EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S080	6061-T6 .080 Sheet
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**Comment:** Qty.: 0.5355 sf(s)/Unit Total : 5.3550 sf(s)

6061-T6 .080 Sheet

Batch: 107904 IB 8-6-3

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3594

Dwg Rev: AProg Rev: AIB 8-6-3

⑩

2-Deburr if necessary IB 8-6-3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-6-3**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECKS 08/06/03 ccc

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

C'SINK AS PER DWG D3594

08/06/03 ⑩

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: DOOR DOUBLER

Job Number: 39575

Part Number: D3594043

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*08.06.04 (10)*



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*BR 08.06.04*

*(10)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FL 08/06/04 (10)*

9.0

MS210695

Anchor nuts



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Anchor nuts

BATCH: *M107938*

*CP 08/06/10*

10.0

MS20426AD44

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)

Rivet

BATCH: *M1021*

*CP 08/06/10*

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates As per Dwg D3594

*CP 08/06/10*

*(10)*

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*S 08/06/10 (10)*

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57040*

*CP 08/06/11 (10)*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR DOUBLER

Job Number: 39575

Part Number: D3594043

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08/06/12 JA  
MF 08-06-12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

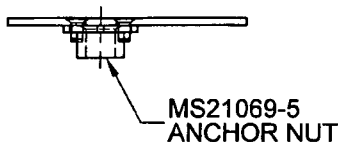
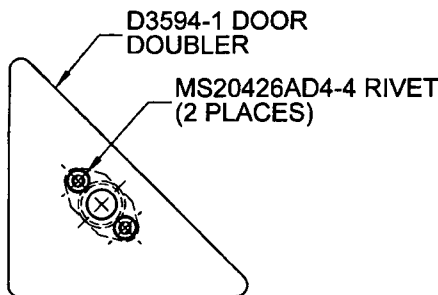
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

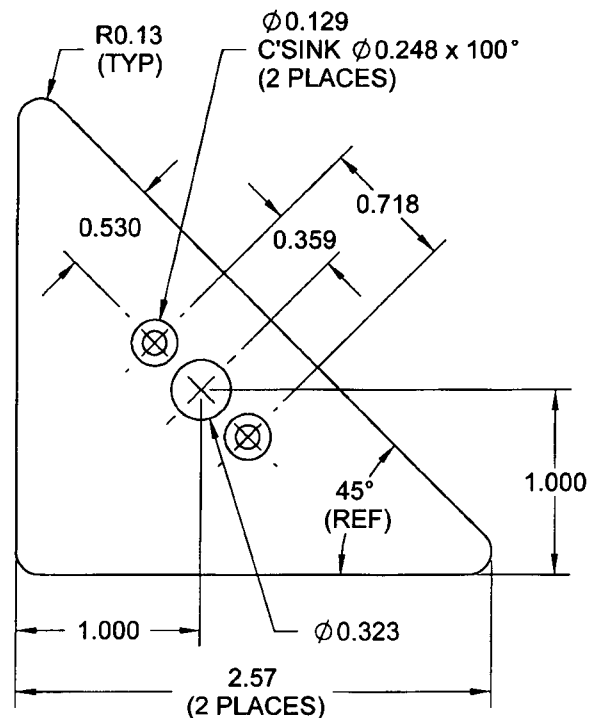


**DART****RELEASED**  
07.07.11  
Per [signature]

DESIGN [signature]	DRAWN BY [signature]	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [signature]	APPROVED [signature]	DRAWING NO. <b>D3594</b>	REV. A SHEET 1 OF 3
DATE <b>07.04.13</b>	TITLE <b>DOUBLER</b>		SCALE 1:1
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

**D3594-041 DOOR DOUBLER ASSEMBLY**   
SCALE 1 : 2

QTY -041	P/N	DESCRIPTION
X	D3594-041	DOOR DOUBLER ASSEMBLY
1	D3594-1	DOOR DOUBLER
1	MS21069-5	ANCHOR NUT
2	MS20426AD4-4	RIVET

**D3594-1 DOOR DOUBLER** **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.080 THICK, PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.080)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-041" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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WORK ORDER  
NO. 89575

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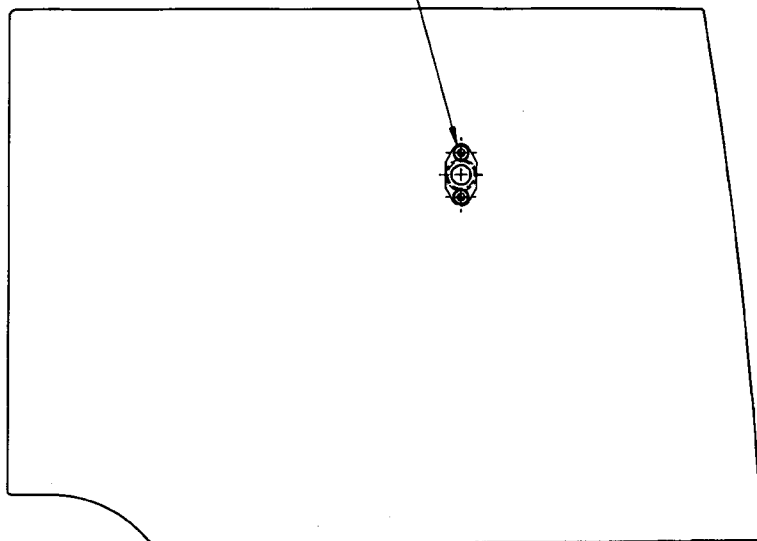


DESIGN <i>B</i>	DRAWN BY <i>B</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3594</b>	REV. A SHEET 2 OF 3
DATE <b>07.04.13</b>		TITLE <b>FLOOR DOUBLER ASSEMBLY</b>	SCALE 1:3

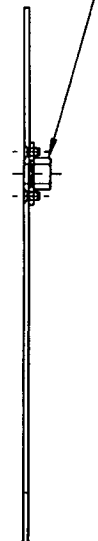
**RELEASED**

07.07.11  
Per 6061-T6

MS20426AD4-4 RIVET  
(2 PLACES)



MS21069-5  
ANCHOR NUT



D3594-3 FLOOR DOUBLER (D3594-043)  
D3594-4 FLOOR DOUBLER (D3594-044)

**D3594-043 FLOOR DOUBLER ASSEMBLY**  
**(D3594-044 OPPOSITE)**

QTY -043	QTY -044	P/N	DESCRIPTION
X		D3594-043	FLOOR DOUBLER ASS'Y, LH
	X	D3594-044	FLOOR DOUBLER ASS'Y, RH
1		D3594-3	FLOOR DOUBLER, LH
	1	D3594-4	FLOOR DOUBLER, RH
1	1	MS21069-5	ANCHOR NUT
2	2	MS20426AD4-4	RIVET

**NOTES:**

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- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3594-043/-044" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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WORK ORDER  
NO. 39575

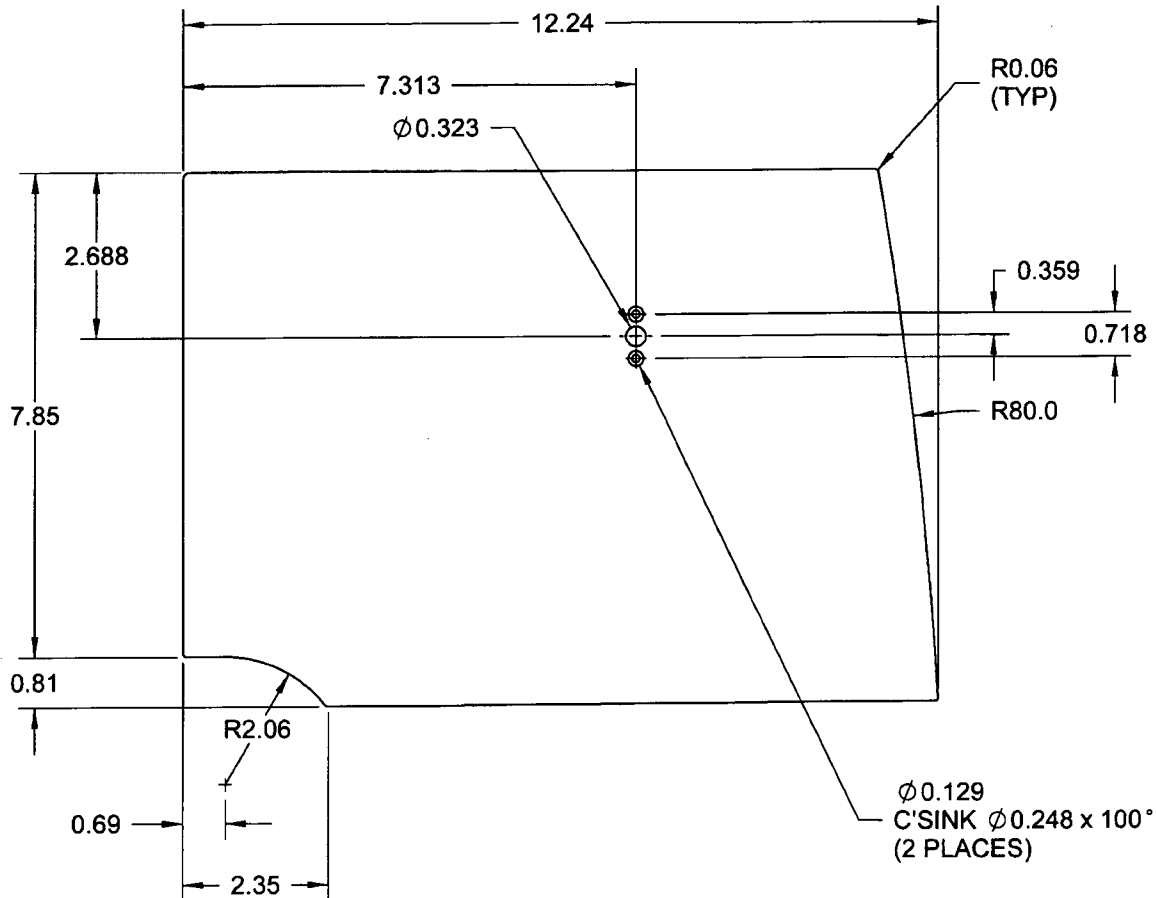
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CHECKED H	APPROVED H	DRAWING NO. D3594	REV. A SHEET 3 OF 3
DATE 07.04.13		TITLE DOUBLER	SCALE 1:3

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07.07.11  
PER 60541001



**D3594-3 FLOOR DOUBLER**  
**(D3594-4 OPPOSITE)**

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